

Date: Monday, 29/09/2008 11:55:06 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SUPPORT ASSEMBLY
Job Number :	42320		
Estimate Number :	10464		
P.O. Number :		Part Number :	D3278041
This Issue :	29/09/2008	Drawing Number :	D3278 REV.C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	///	Drawing Revision :	C
Previous Run :	41346	Material :	
Written By :		Due Date :	10/10/2008
Checked & Approved By :	<u>JUL 08.9.29</u>	Qty:	40
Comment :	Est:A 04.04.19 New issue KJ/JLM	Um:	Each
	EST B 07.08.21 Chg rivet per PAR185		
	by: JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	42320A	SUPPORT
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Comment: Sub-Component SUPPORT
 1 x D3278-1 Batch

B 36811 A (25x)

B 42320 (15x)

2.0	42320B	SUPPORT
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Comment: Sub-Component SUPPORT
 1 x D3278-2 Batch

B 36811 B (21x)

B 42320 (19x)

3.0	D32783	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Spacer

Pick:

Qty	Part Number	Description	Batch
1	D3278-3	Spacer	B 41451

4.0	MS20426AD36	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)

RIVET

Pick:

Qty	Part Number	Description	Batch
4	MS20426AD3-6	Rivet	M 105055

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 29/09/2008 11:55:06 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 42320

Part Number: D3278041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Rivet spacers with support as per Dwg D3278.

CP 08/10/28 (40)

6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

08/10/28 (40) counter

7.0	D22301	Lug
-----	--------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)
Mounting Lug
Pick: Packing Kit
Qty Part Number Description Batch
2 D2230-1 Mounting Lug

CP 08/10/28

Batch *B40934* (27x)

B41819 (53x)

8.0	AN413A	Bolt
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)
Bolt
Pick: Packing Kit
Qty Part Number Description Batch
2 AN4-13A Bolt

Batch *M109282*

CP 08/10/28

9.0	AN960JD416	Washer
-----	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 160.0000 Each(s)
Washer
Pick: Packing Kit
Qty Part Number Description Batch
4 AN960JD416 Washer

Batch *M108827*

CP 08/10/28

10.0	MS21042L4	Nut
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 80.0000 Each(s)
Nut
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L4 Nut

Batch *M108145*

CP 08/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT ASSEMBLY

Job Number: 42320

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

08/10/29 (40)

12.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

08/10/29 (40)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



(40X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *471*

8/10/29

SO

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

08/10/29

Job Completion



u 08.10.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

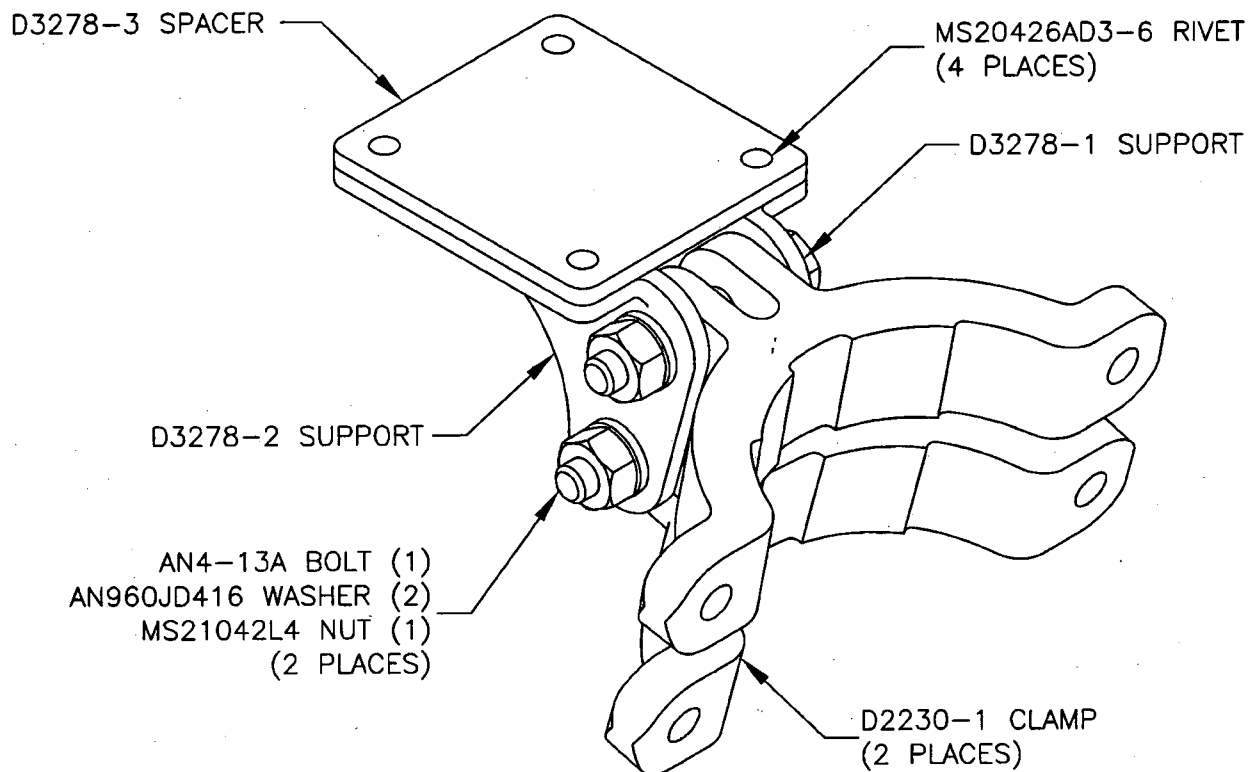
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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WITHOUT NOTICE
WORK ORDER
NO. *42320*

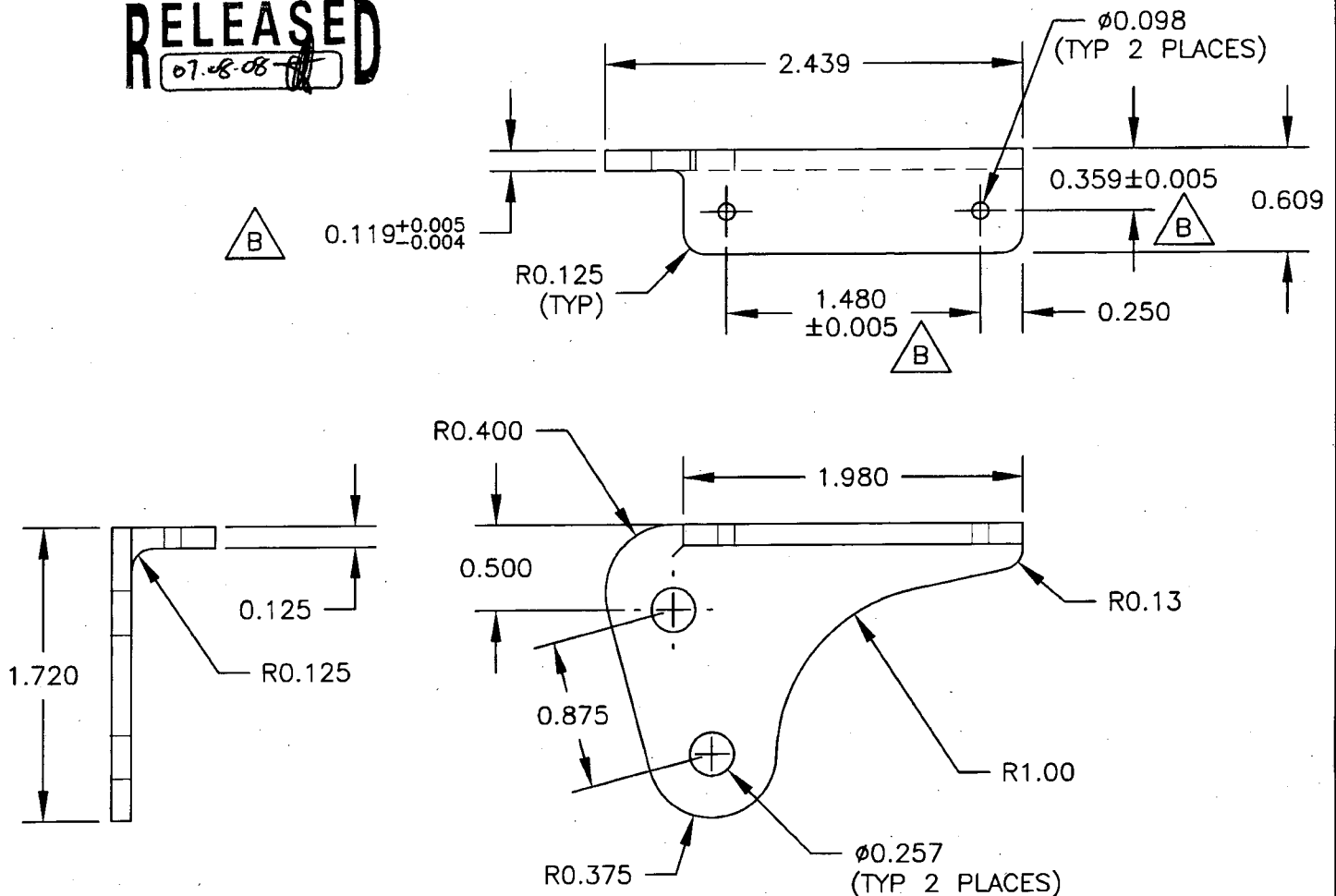
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DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07-08-08



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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WORK ORDER
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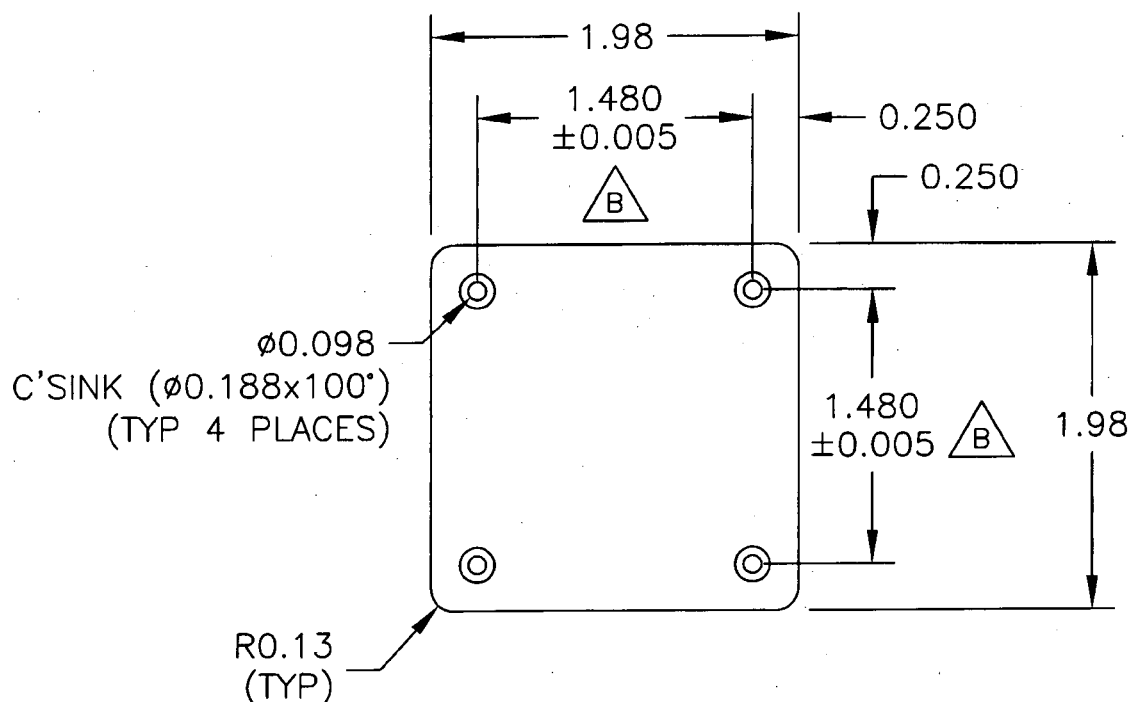
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DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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